

# Work Order ID 60951

Thursday, July 29, 2010 1:21:31 PM



Page 1

Item ID: D350-588-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Assembly

Start Date: 7/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2010 Req'd Qty: 1.00



Customer:

Reference: Return 2010 RA110067

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: 2 Date: 10/7/29 SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D

100 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo  
Original B54832 @ CHG003. Kit is complete.

0.00

8 8/10/07/30

110 Identify as per dwg & Stock Location: 42 0.00



Packaging

Packaging

Memo  
New paperwork & labels required with the new batch # @ CHG003

0.00

8/10/07/30

REUD

Pick New Kit

10/07/29

10/07/30

120 QC21- Final Inspection - Work Order Release 0.00



QC

Quality Control

Memo 0.00

10/08/03

10/07/30

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# Picklist Print

Thursday, July 29, 2010 1:21:30 PM

Page 1

Work Order ID: 60951

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/29/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04 Reformat KJ/DS IPP Rev:Q as  
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD  
10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN526C1032R7 Purchased No



Screw

Location

Loc Qty

Loc Code

ST328

62

113064

11

113749

1

114056

50

AN526C832R8 Purchased No



Screw

Location

Loc Qty

Loc Code

ST327

196

114615

96

114718

100

AN960JD10 NAS1149D0363J Purchased No



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

AN960JD8 NAS1149DN832L Purchased No



Washer

2 12 7/7/308 5

8 8 10/7/308

4 4

11/5/07 10/7/308

16 24

11/23/83 10/7/308

**Abstract**

11

[illegible]

1

*Journal of Management Studies*, 19(6), 709-728.

424

the 1990s, the number of people in the United States who are 65 years of age or older is projected to increase from 20 million to 30 million, and the number of people 75 years of age or older is projected to increase from 10 million to 15 million (U.S. Census Bureau, 1996).

2

1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	2101	2102	2103	2104	2105	2106	2107	2108	2109	2110	2111	2112	2113	2114	2115	2116	2117	2118	2119	2120	2121	2122	2123	2124	2125	2126	2127	2128	2129	2130	2131	2132	2133	2134	2135	2136	2137	2138	2139	2140	2141	2142	2143	2144	2145	2146	2147	2148	2149	2150	2151	2152	2153	2154	2155	2156	2157	2158	2159	2160	2161	2162	2163	2164	2165	2166	2167	2168	2169	2170	2171	2172	2173	2174	2175	2176	2177	2178	2179	2180	2181	2182	2183	2184	2185	2186	2187	2188	2189	2190	2191	2192	2193	2194	2195	2196	2197	2198	2199	2200	2201	2202	2203	2204	2205	2206	2207	2208	2209	2210	2211	2212	2213	2214	2215	2216	2217	2218	2219	2220	2221	2222	2223	2224	2225	2226	2227	2228	2229	2230	2231	2232	2233	2234	2235	2236	2237	2238	2239	2240	2241	2242	2243	2244	2245	2246	2247	2248	2249	2250	2251	2252	2253	2254	2255	2256	2257	2258	2259	2260	2261	2262	2263	2264	2265	2266	2267	2268	2269	2270	2271	2272	2273	2274	2275	2276	2277	2278	2279	2280	2281	2282	2283	2284	2285	2286	2287	2288	2289	2290	2291	2292	2293	2294	2295	2296	2297	2298	2299	2300	2301	2302	2303	2304	2305	2306	2307	2308	2309	2310	2311	2312	2313	2314	2315	2316	2317	2318	2319	2320	2321	2322	2323	2324	2325	2326	2327	2328	2329	2330	2331	2332	2333	2334	2335	2336	2337	2338	2339	2340	2341	2342	2343	2344	2345	2346	2347	2348	2349	2350	2351	2352	2353	2354	2355	2356	2357	2358	2359	2360	2361	2362	2363	2364	2365	2366	2367	2368	2369	2370	2371	2372	2373	2374	2375	2376	2377	2378	2379</
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...the ...

*(The following information was obtained from the records of the Department of Social Services, State of New York, Office of Child Welfare, dated 10/18/67.)*

CONFIDENTIAL

# Picklist Print

Thursday, July 29, 2010 1:21:31 PM

Page 2

Work Order ID: 60951

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

D2143 Manufactured No



Hinge Bracket

Location

ST198

55323

Loc Qty

17

17

Each

17.0000



Start Date: 7/29/2010

Start Qty: 1.00

Required Date: 8/5/2010

Required Qty: 1.00

Loc Code



1

1

10/7/30

N/A S

D2144 Manufactured No



Hinge Bracket

Location

ST198

55179

Loc Qty

42

42

Each

42.0000



Loc Code



1

1

10/7/30

N/A S

D2150 Manufactured No



Packer Doubler, Hinge

Location

ST007

55016

55178

Loc Qty

36

2

34

Each

36.0000



Loc Code



2

2

10/7/30

N/A S

D2151 Manufactured No



Packer Doubler, Hinge

Location

ST007

51407

55319

Loc Qty

21

2

19

21.0000



Loc Code



2

2

10/7/30

N/A S

Thursday, July 29, 2010 1:21:31 PM

Shop Packet Print

Page 2

# Picklist Print

Thursday, July 29, 2010 1:21:31 PM

Page 3

Work Order ID: 60951

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/29/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

5 D2153  
Door Prop

Manufactured No

Each 39.0000

Location

Loc Qty

Loc Code

ST272

39

48373

1

55324

2

59818

36

5 D2154  
Stud Bracket

Manufactured No

Each 11.0000

Location

Loc Qty

Loc Code

ST

1

44890

1

ST007

10

55325

10

5 D2237  
Striker Plate

Manufactured No

Each 35.0000

Location

Loc Qty

Loc Code

ST009

35

58181

35

X D2461  
Neoprene "D" Seal

Manufactured No

f 220.1472

7.25

Location

Loc Qty

Loc Code

ST402

220.1472105

39782

13.75

55054

206.397211

6 +1 @ 87" long  
L7 measure  
S106712

Thursday, July 29, 2010 1:21:31 PM

Shop Packet Print

Page 3

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# Picklist Print

Thursday, July 29, 2010 1:21:31 PM

Page 4

Work Order ID: 60951

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/29/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2589 Manufactured No

Each

200.0000



Keys, Key Chain, 350 Hinge



1

1

10/7/30 SP

## Location

## Loc Qty

## Loc Code

ST019

200

58194

200

Each

74.0000



2

2

10/7/30 SP

D2621

Manufactured No



Latch Plate, 350 Spacepod

N/A

## Location

## Loc Qty

## Loc Code

ST021

74

46842

8

56526

66

Each

5.0000



1

1

10/7/30 SP

D2690-17

Manufactured No



Cable

## Location

## Loc Qty

## Loc Code

ST021

4

58212

4

ST41

1

50666

1

Each

23.0000



1

1

10/7/30 SP

D2858-1

Manufactured No



Hinge Bracket

## Location

## Loc Qty

## Loc Code

ST027

23

45798

1

55062

1

56423

21



1

1

10/7/30 SP

Thursday, July 29, 2010 1:21:31 PM

Shop Packet Print

Page 4



# Picklist Print

Thursday, July 29, 2010 1:21:31 PM

Page 5

Work Order ID: 60951

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/29/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

D2858-2

Manufactured No

Each

15.0000

1

1



Hinge Bracket



10/7/30

## Location

## Loc Qty

## Loc Code

ST

1

45799

1

ST027

14

56048

14

MS20426AD3-4

Purchased

No

Each

6,552.000

12

12



RIVET



10/7/30

## Location

## Loc Qty

## Loc Code

ST316

6552

104374

2552

110398

4000

MS20470AD4-5

Purchased

No

Each

1,385.000

18

18



Rivet, Universal Head



10/7/30

## Location

## Loc Qty

## Loc Code

ST309

1320

114761

1320

ST319

65

111916

65

MS21042L08

Purchased

No

Each

400.0000

18

18



Nut



10/7/30

## Location

## Loc Qty

## Loc Code

ST300

400

115016

200

115300

200

4 + 10

Thursday, July 29, 2010 1:21:31 PM

Shop Packet Print

Page 5

# Picklist Print

Thursday, July 29, 2010 1:21:31 PM

Page 6

Work Order ID: 60951

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/29/2010

Required Date: 8/5/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,472.000

4

Nut

## Location

## Loc Qty

## Loc Code

ST300

2472

114523

115

114718

357

114784

2000

Each

69.0000

2

MS27039-08-11

Purchased

No

Screw

## Location

## Loc Qty

## Loc Code

ST288

50

114382

50

ST290

19

111977

2

113749

17

Each

99.0000

2

MS27039-1-1

Purchased

No

Screw

## Location

## Loc Qty

## Loc Code

ST292

99

114056

2

114718

97

5 1.59 foot of 902 cloth.

B<sup>12</sup> M114666

10/7/30 SP

Thursday, July 29, 2010 1:21:31 PM

Shop Packet Print

Page 6

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**3.3 WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

**3.4 PARTS LISTS**

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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Revision: D

Date: 02.01.17

## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
		<del>D2143</del>	HINGE DOUBLER
		<del>D2144</del>	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
		<del>D2463-0870</del>	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
		<del>D2585</del>	LATCH CLAMP
		<del>D2586</del>	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
		<del>D2621</del>	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
		<del>D2857-1</del>	LOWER HINGE BRACKET
		<del>D2857-2</del>	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
		<del>AN526C832R9</del>	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER -8
4	4	AN960JD10	WASHER -2
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08) -8
4	4	MS21042L3	NUT (or MS21042-3) -2
		<del>MS27039-1-15</del>	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

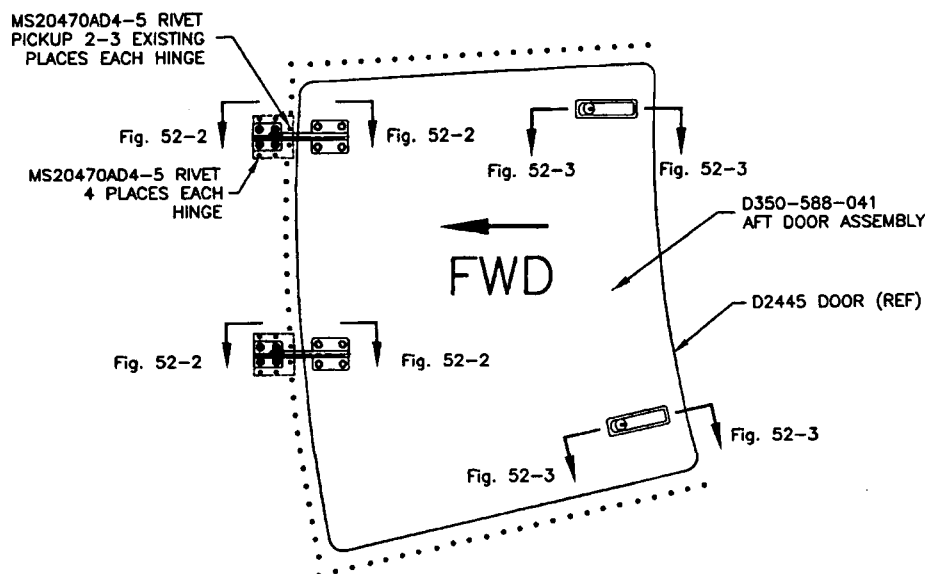


Figure 52-1: Baggage Door Outside View

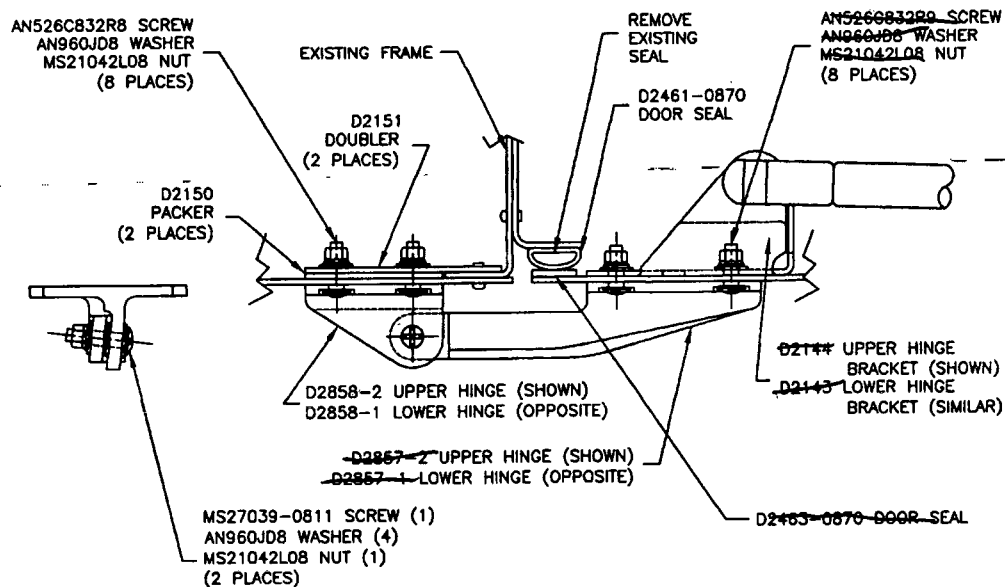


Figure 52-2: Hinge Detail

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52-00-00

REFERENCE ONLY

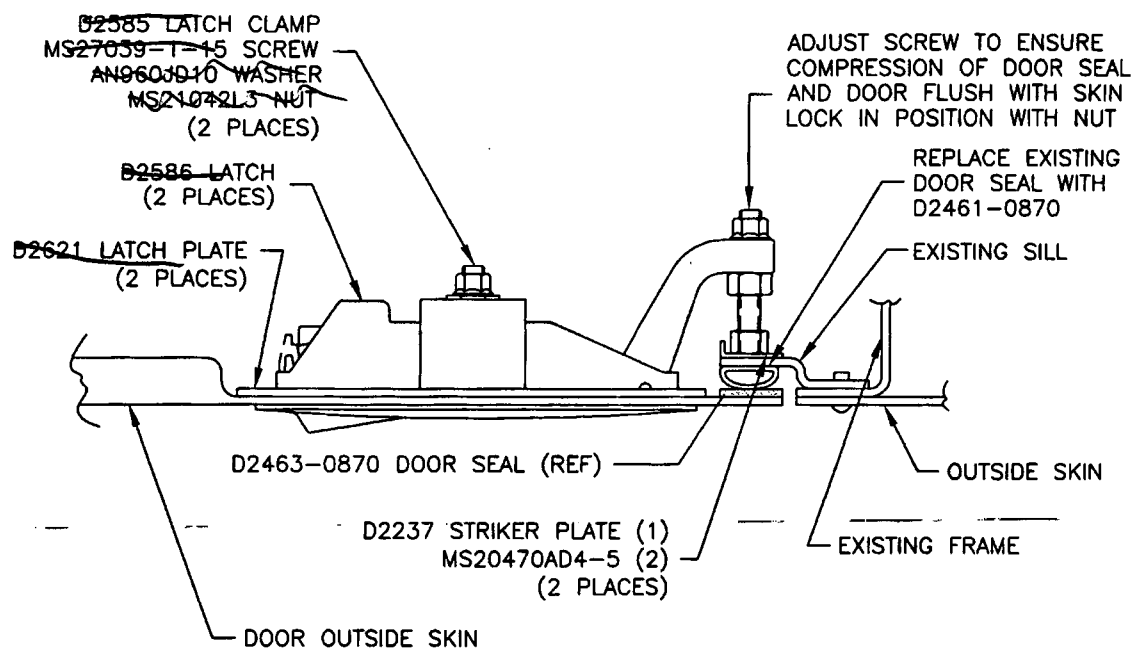


Figure 52-3: Latch Section

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